

Work Order ID 68797

Thursday, April 21, 2011 8:04:45 AM



Page 1

Item ID: D2888

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 4/20/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-04-21

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2888

Rev A2

100

0.00



Bandsaw

Jeaspa Bandsaw

Memo

Cut Blanks at 4.200" long
Grain along 4.200"*

0.00

[Signature] 11.05.10

8

Ø

110

0.00



HAAS 1

HAAS CNC vertical machine #1

Memo

Machine as per Folio D2888

Folio Rev: AA

Dwg Rev: A2

0.00

B.A 11/05/11

8

Ø

2-Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Memo

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

B.A 11/05/11

8

0

130



QC

Memo

Quality Control

QC8- Inspect parts - second check

0.00

0.00

SL 11/05/16

8

140



HandFinish

Memo

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

8X 0 M-11/05/16

W/O:		WORK ORDER CHANGES					
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Work Order ID 68797

Thursday, April 21, 2011 8:04:46 AM



Page 3

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Item Name: Lug

Start Date: 4/20/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3=30
320 01=
4=00

0.00

8x ~~Ø~~ m-11/05/10

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

8 BL 11-5-17

170



Packaging

Packaging

Identify as per dwg & Stock Location:

980

0.00

Memo

0.00

Put 12 (8)

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/18 AJ

11-05-18
(4)

W/O:		WORK ORDER CHANGES					
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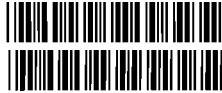
NOTE: Date & initial all entries

Picklist Print

Thursday, April 21, 2011 8:04:55 AM

Page 1

Work Order ID: 68797



Parent Item: D2888

Parent Item Name: Lug

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP C00.06.22 Removed P/O for powder coat EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.500X03.50 0		Purchased	No			100	f	8.5000	0.39	3.12			



6061-T6 Bar 2.50 x 3.50

Location

MAT008

113403

Loc Qty

8.5

8.5

Loc Code

4/21/11-05-10

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DART AEROSPACE LTD		Work Order:	68797
Description: Lug		Part Number:	D2888
Inspection Dwg: D2888	Rev: A2	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.386	+0.005/-0.000	Ø0.390	✓		Vern	GA-01
Ø0.88	+/-0.030	Ø0.875	✓		"	"
0.063 x 45°	+/-0.010	0.058 x 45°	✓		"	"
4.06	+/-0.030	4.055	✓		H-G	31006
Ø0.760	+0.005/-0.000	Ø0.7625	✓		Vern	GA-01
3.48	+/-0.030	3.480	✓		H-G	31006
2.500	+/-0.010	2.499	✓		Vern	GA-01
2.75	+/-0.030	2.750	✓		"	"
0.438	+/-0.010	0.438	✓		"	"
0.080 x 45°	+/-0.010	0.082 x 45°	✓		"	"
1.85	+/-0.030	1.849	✓		"	"
1.000	+/-0.010	1.002	✓		"	"
0.425	+/-0.010	0.423	✓		"	"
0.030 x 45°	+/-0.010	0.025 x 45°	✓		"	"
1.875	+/-0.010	1.871	✓		H-G	31006
0.375	+/-0.010	0.374	✓		Vern	GA-01
R0.25	+/-0.030	R0.250	✓		R-G	ref.
1.29	+/-0.030	1.288	✓		Vern	GA-01
0.414	+/-0.010	0.412	✓		H-G	31006
3.41	+/-0.030	3.410	✓		Vern	GA-01

Measured by: K.A.	Audited by: SL	Prototype Approval:	N/A
Date: 11/05/11	Date: 11/05/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.06.04	New Issue	KJ/DD	

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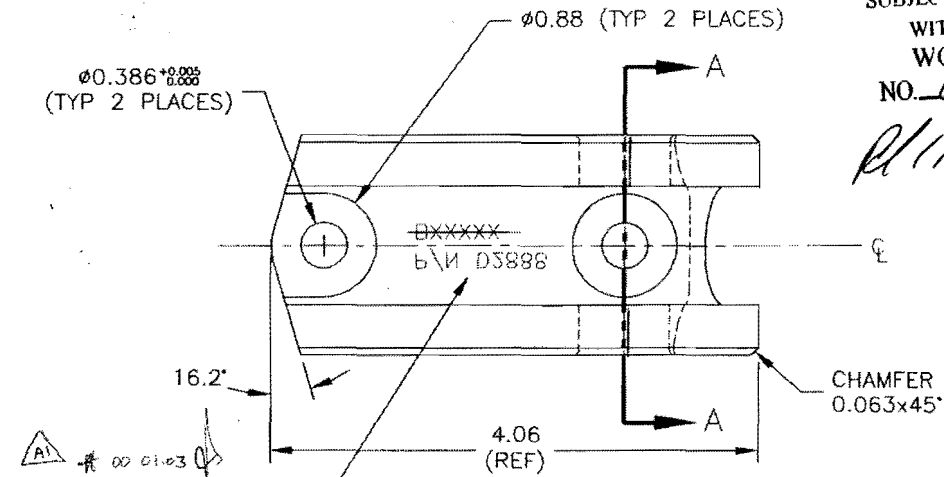
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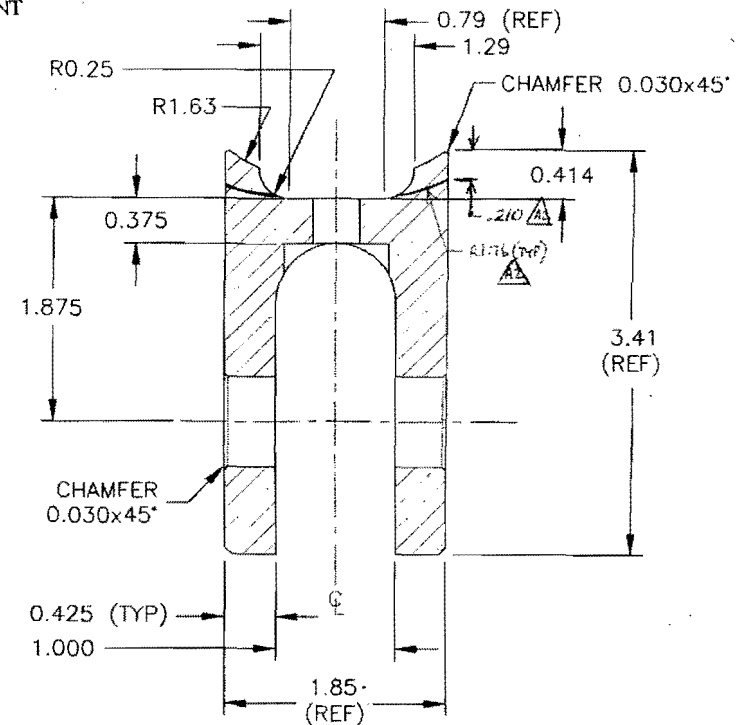
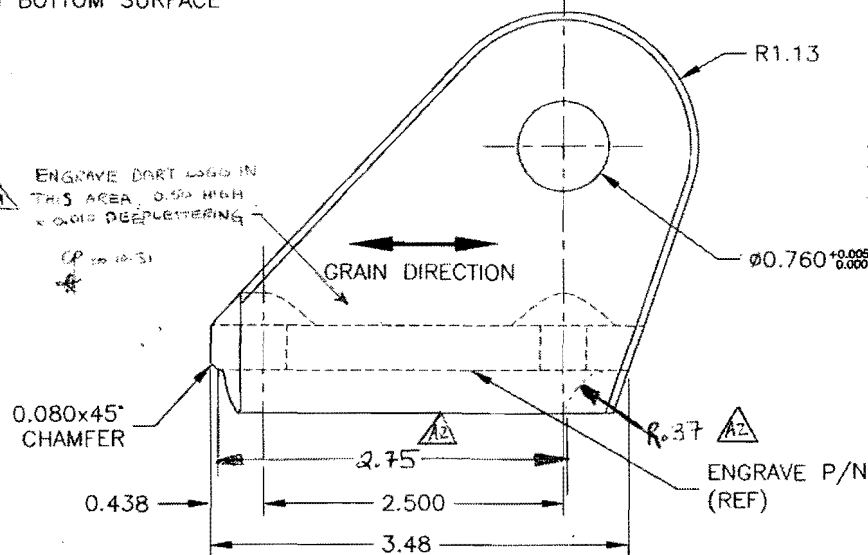
SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68797
R/11 09-21



ENGRAVE DART PART
NUMBER AND BATCH
NUMBER IN THIS AREA
ON BOTTOM SURFACE

ENGRAVE DART LOGO IN
THIS AREA, 0.010 HIGH
& 0.010 DEEP LETTERING



SECTION A-A
SCALE 1:1

RELEASED
99.07.09 DS

MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR
QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
BREAK UNMARKED EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

A2	04.04.08	Add Surface Clearance Per NCR 754
A1	00.10.21	Update Engineering

A	99.06.21	NEW ISSUE
DESIGN	DRAWN BY	DART AEROSPACE LTD HAMPSHIRE, ENGLAND, CANADA
CHECKED	APPROVED	DART
DATE	DRAWING NO.	REV. A
99.06.21	D2888	SHEET 1 OF 1
	TITLE	SCALE
	LUG	1:1

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